



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3012

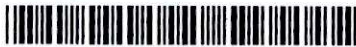
Job Sheet 200357



Part No: 646.3012

Job Qty: 12 pcs

Part Name: Lower Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEETS 1,3,5,8,9 IPP REV:A NEW ISSUE 13/01/30 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		10/15/19	0.00	0.86	Bandsaw - 1		SBL 19/10/17
110	HAAS 4 Axis - B4B	12 pcs		10/15/19	0.20	13.79	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B		SBL 19/10/17
120	QC 2	12 pcs		10/15/19	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62		VH8 19/10/17

DAS
23
9-89



Container No: S224194



Part: 646.3012

Job No: 200357

Serial No/Batch: S224194

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/19/19

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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	12 pcs	10/15/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	DAS
					QC 8 - 52	52
					QC 8 - 23	9-89
					QC 8 - 57	
					QC 8 - 76	
140	Outsource - 4 - Anodize	12 pcs	10/15/19		ATG001-VC	5
						2019-11-04
150	Packaging 2-1 - Receive - B4B	12 pcs	10/15/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	11/22/2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	

					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155	QC 6	12 pcs	10/15/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
180	Packaging 3-1 - Stock - B4B	12 pcs	10/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	

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Oscar (CCK013)

DEC 05 2019

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	28 pcs	10/15/19	0.00 0.00	QC 21 - SA - 21 ✓	CEK 013
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
Part Op 100 - Cut Blank at 27.500" ***ONE BLANK MAKE TWO PARTS*** Descriptions: 110 - 1-Machine per folio FB159 120 - Machining-1 (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - Issue P/O to ATG : <u>44992</u> Hard Anodize, Color Black and Prime as per Dwg 646.3000 150 - (QC5- Inspect part completeness to step on W/O) 155 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6S0.375X8.000	7075-T6S Sheet .375" Thick Plate X 8" Wide	13.7520 ft (1.146 ea)	100-Bandsaw - 1		

DEC 06 2019

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S0.375X8.000	14	12	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Lower Guide	0.125inches ± 0.005	0.130 0.120	0,128
2	Lower Guide	45.000Degrees ± 0.500	45.500 44.500	45° Angle
3	Lower Guide	0.375inches ± 0.005	0.380 0.370	,373
4	Lower Guide	0.250inches ± 0.005	0.255 0.245	,250 Radius
5	Lower Guide	0.209inches + 0.005 - 0.001	0.214 0.208	,209 Diameter
6	Lower Guide	0.177inches + 0.005 - 0.001	0.182 0.176	,177 Diameter
7	Lower Guide	0.250inches ± 0.005	0.255 0.245	,250

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$S155923 \times 117.312_{po} \rightarrow 7.062_{po}$
 $S221696 \times 145_{po} \rightarrow 7.125_{po}$
 $S221696 \times 145_{po} \rightarrow 7.1872_{po}$

Striper

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044992**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044992

PO Date: 11/4/19

Due Date: 11/22/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-15

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197351	RBE350A93-3205-00T	RBE350A93-3205-00T Rev 3C	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed X16	-	11/22/19	16 pcs	0 pcs	16 pcs	\$6.63/pcs	\$106.08
2	200357	646.3012	646.3000 Rev NC	Lower Guide : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed X28	-	11/22/19	28 pcs	0 pcs	28 pcs	\$20.78/pcs	\$581.84
3	202282	D2348	D2348 Rev C	Wearplate (Key Way) : Various STC's Issue P/O: Black Anodize per Dwg D2348 Rev. C	Firmed X10	-	11/11/19	60 pcs	0 pcs	60 pcs	\$1.83/pcs	\$109.80
4	201033	RBH9928-2	RBH9928-2 Rev K	Trim Tab Bender Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed X10	-	11/11/19	10 pcs	0 pcs	10 pcs	\$6.63/pcs	\$66.30

NOV 15 2019

NOV 22 2019

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989

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044992**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	200996	646.3811	646.3800 Rev A	Radius Block : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	11/22/19	28 pcs	0 pcs	28 pcs	\$7.43/pcs	\$208.04

Grand Total: \$1,072.06

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918998

Date: 20-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

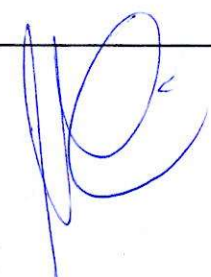
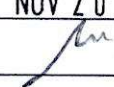
Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
28 ea	Part: 646.3012 Lower Guide Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# <u>120908</u> Job: 26392 PO: POHB044992	Rev: NC Expiry Date: <u>10/20</u> Line: 2	 DAS 40 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>NOV 20 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

RECEIVED
NOV 21 2019
DART AEROSPACE LTD.